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U/R
ML
3/15/20

D5815-041
Job Sheet 207563



Part No: D5815-041

Job Qty: 4 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Due Date: 4/27/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG 5815 REV.A IPP REV:A NEW ISSUE 20.01.17 JV VERF:DD

Ship Via:

POSITIVE RECORD
EFFECTIVE 3/15/20 AUTH ML
RELEASED _____ DATE _____

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs			0.00	4.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		ML
							Large Fab - 12		
110	QC 9	4 pcs			0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 50	9-89	
							QC 9 - 9		
120	QC 5	4 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S268602



Part: D5815-041

Job No: 207563

Serial No/Batch: S268602

Revision: REV.A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 04/02/20

Plex 3/12/20 8:08 AM Dart Lajeunesse, Marie

			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 61	
130 Packaging 3-1 - Stock - B4B 4 pcs	0.00 0.00		Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
140 QC 21 - SA 4 pcs	0.00 0.00		QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

DAS
24
9-09

ML 20-04-07

Part Op 100 - 1- Fabricate as per D5815-041 dwg 2- Weld per dwg A/R 4130 rod Batch: 0139072

Descriptions: 110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

M4 # 015299

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5770-9 ✓	Bushing	8 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5265462
D5805-5 ✓	Cap	4 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5263940
D5815-1 ✓	Hoop	4 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5264778
D5815-3 ✓	Hoop	4 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5264657
D5815-5 ✓	Stud	4 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5267218
D5815-7 ✓	Stud	4 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5267219

Job Allocations

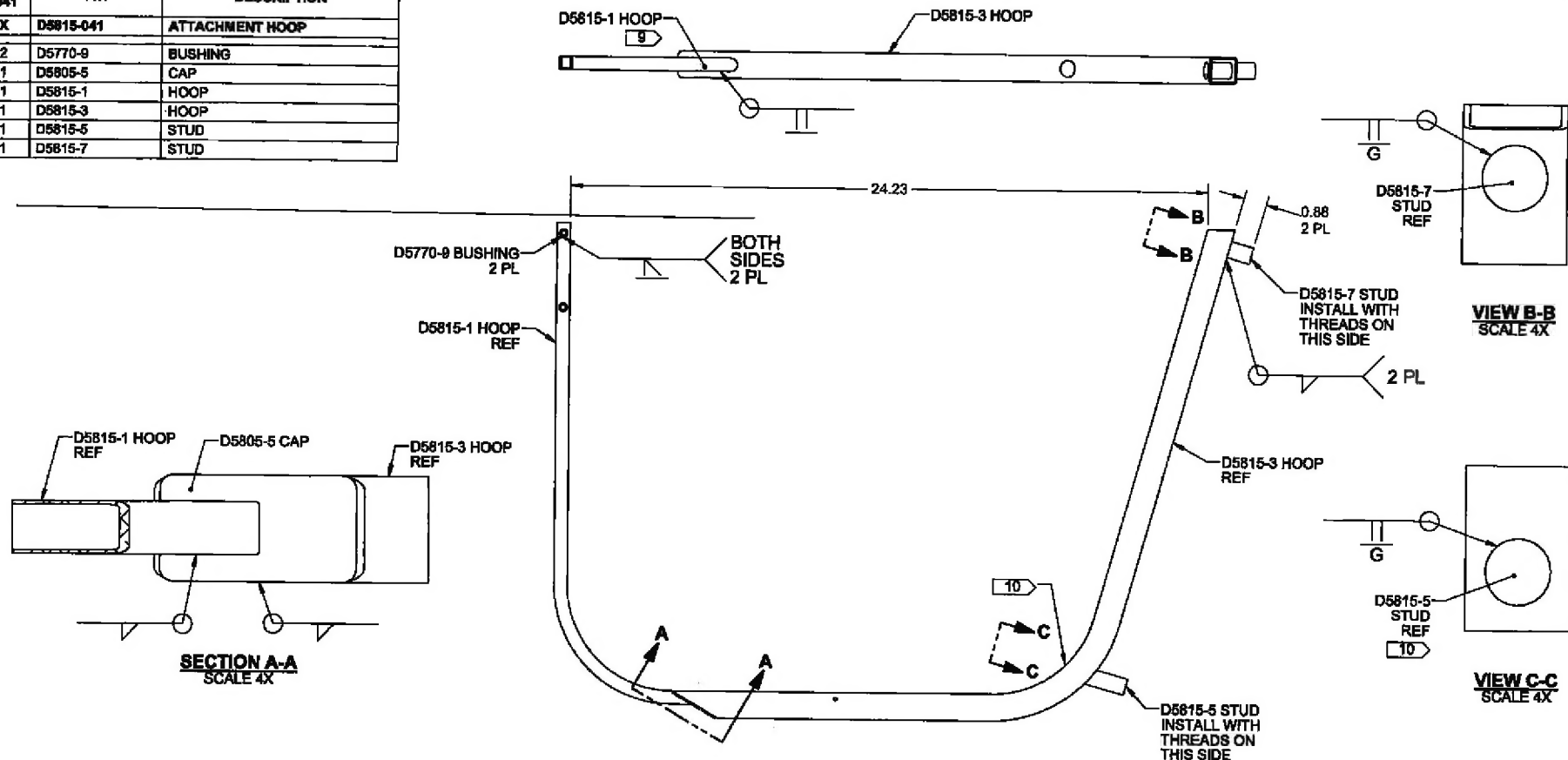
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5770-9	8	12	0
	D5805-5	4	4	0
	D5815-1	4	0	0
	D5815-3	4	0	0
	D5815-5	4	0	0
	D5815-7	4	0	0

Part Specifications

Specifications could not be found.

Plex 3/12/20 8:06 AM Dart.lajeunesse.mario

QTY -041	P/N	DESCRIPTION
X	D5815-041	ATTACHMENT HOOP
2	D5770-8	BUSHING
1	D5805-5	CAP
1	D5815-1	HOOP
1	D5815-3	HOOP
1	D5815-5	STUD
1	D5815-7	STUD



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207563 M.L.
2003-12

RELEASED
 2020 FEB 18 MD
 ECN2020-521

UNDER REVIEW
 URF 2020-522 20.02.14 (NO)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 2.85 lbs
 - 8) WELD PER DART QSI 004
 - 9) GRIND END OF D5815-1 HOOP TO FIT SLOT OF D5815-3 HOOP
 - 10) GRIND END OF D5815-5 STUD FLUSH TO INSIDE OF D5815-3 HOOP

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.13
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.13		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5815
 TITLE
BASKET HOOPS

REV. A
 SHEET 1 OF 5
 SCALE
 NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					